

Date: Thursday, 4/12/2007 8:45:02 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	31719				
Estimate Number	10530				
P.O. Number	N/A	Part Number	D2571		
This Issue	4/12/2007	S.O. No.	N/A		
Prsht Rev.	NC		Drawing Number	D2571 REV E	
First Issue	N/A	Type	MACHINED PARTS	Project Number	N/A
Previous Run	31716			Drawing Revision	E
Written By			Material	N/A	
Checked & Approved By			Due Date	4/30/2007	Qty: 16 Um: Each
Comment	Est: 10240.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	

Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No:

B25355 (x11)

Er 07/15/15

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No: 31719 Double check by: JL

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

Er / MS 07/05/23 16

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

Er / MS 07/05/23 16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Er / MS 07/05/23 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:45:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31719

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 07/05/23

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-05-28

(16)

7.0 POWDER COATING POWDER COATING



M 103/41

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SL/M-A

07-05-29

(16)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL 07/05/29 (16)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SL 07/05/29 (16)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

SL 07/05/29

Job Completion



U 07-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 31719	
Description: Saddle, Fwd Outboard				Part Number: D2571	
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	-DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.745	1.750	1.750	1.749		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.745	1.750	1.750	1.750		
E	7.990	8.010		7.992	7.997	7.998	8.002		
F	0.490	0.510		0.496	.497	.498	.500		
G	0.257	0.262	-DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.379	0.377	0.377		
I	0.490	0.510		0.500	.500	.500	.500		
J	1.174	1.184		1.175	1.179	1.179	1.179		
K	0.558	0.578		0.563	.563	.563	.563		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.490	1.500		1.493	1.495	1.496	1.496		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		0.126	.125	.125	.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	.250	.250	.250		
S	0.115	0.135		0.126	.125	.125	.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	.245	.247	.245		
W	0.115	0.135		0.120	.125	.125	.131		
X	0.308	0.313		0.310	.312	.312	.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	.367	.368	.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	.625	.625	.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	.250	.250	.250		
AE	1.375	1.395		1.384	1.385	1.386	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	.250	.250	.250		
AI	2.000	2.020		2.002	2.000	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En MS	Audited by:	J.L.
Date:	07/05/17	Date:	07/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31719
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.747	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.499		
D	1.745	1.755		1.750	1.750	1.747	1.748		
E	7.990	8.010		8.001	8.001	8.005	8.004		
F	0.490	0.510		.500	.500	0.493	0.497		
G	0.257	0.262	DT8683	.258	.258	0.260	0.260		
H	0.375	0.380	DT8684	.376	.375	0.377	0.377		
I	0.490	0.510		.500	.500	0.503	0.499		
J	1.174	1.184		1.179	1.179	1.175	1.175		
K	0.558	0.578		.568	.568	0.564	0.565		
L	1.174	1.184		1.179	1.179	1.175	1.175		
M	1.490	1.500		1.496	1.496	1.492	1.492		
N	2.495	2.505		2.500	2.501	2.496	2.498		
O	3.869	3.879		3.874	3.874	3.870	3.872		
P	0.115	0.135		.125	.125	0.127	0.126		
Q	0.115	0.135		.125	.125	0.135	0.135		
R	0.240	0.260		.250	.251	0.251	0.251		
S	0.115	0.135		.125	.128	0.126	0.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.242	0.239	0.236		
W	0.115	0.135		.125	.127	0.121	0.120		
X	0.308	0.313		.312	.312	0.310	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.363	.362	0.362	0.362		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.628	.628	0.630	0.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	0.247	0.250		
AE	1.375	1.395		1.385	1.384	1.384	1.388		
AF	0.115	0.135		.125	.125	0.135	0.135		
AG	0.240	0.280		.250	.250	0.260	0.260		
AH	0.240	0.260		.250	.250	0.249	0.248		
AI	2.000	2.020		2.001	2.001	2.001	2.002		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by: M8 / En
Date: 07/05/18 07/05/19

Audited by: 81
Date: 07.05.21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK JLM

DART AEROSPACE LTD	Work Order:	31719
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.748	1.748	1.750		
C	3.495	3.505		3.499	3.497	3.499	3.498		
D	1.745	1.755		1.747	1.748	1.748	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.001		
F	0.490	0.510		0.501	0.498	0.499	0.499		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.500	0.503	0.498		
J	1.174	1.184		1.177	1.175	1.175	1.175		
K	0.558	0.578		0.565	0.565	0.565	0.563		
L	1.174	1.184		1.177	1.175	1.175	1.175		
M	1.490	1.500		1.492	1.492	1.491	1.495		
N	2.495	2.505		2.498	2.497	2.499	2.498		
O	3.869	3.879		3.872	3.872	3.872	3.871		
P	0.115	0.135		0.127	0.126	0.126	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.250	0.251		
S	0.115	0.135		0.127	0.124	0.126	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.243	0.240	0.244		
W	0.115	0.135		0.118	0.118	0.117	0.119		
X	0.308	0.313		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.365	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.630	0.625	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.246	0.249	0.248		
AE	1.375	1.395		1.387	1.387	1.387	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.250	0.249	0.251		
AI	2.000	2.020		2.001	2.002	2.002	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EP	Audited by:	DA
Date:	07/05/20	Date:	07.05.21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	DA JLM

DART AEROSPACE LTD	Work Order:	31719
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.749	1.750	1.750		
C	3.495	3.505		3.495	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.750		
E	7.990	8.010		8.003	8.001	8.000	7.999		
F	0.490	0.510		0.497	.498	.499	.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	.500	.500	.500		
J	1.174	1.184		1.175	1.178	1.179	1.179		
K	0.558	0.578		0.565	.566	.565	.568		
L	1.174	1.184		1.175	1.178	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.499	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.873	3.873		
P	0.115	0.135		0.125	.125	.125	.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	.249	.250	.250		
S	0.115	0.135		0.127	.128	.128	.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		0.242	.240	.242	.240		
W	0.115	0.135		0.170	.123	.125	.125		
X	0.308	0.313		0.310	.312	.312	.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	.365	.365	.365		
AA	0.470	0.530		0.560	0.500	0.500	0.500		
AB	0.615	0.635		0.605	.625	.625	.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	.248	.247	.246		
AE	1.375	1.395		1.384	1.384	1.386	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	.251	.250	.250		
AI	2.000	2.020		2.002	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>John MB</i>	Audited by:	<i>J.L.</i>
Date:	07/05/23	Date:	07/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

